10. (Amended) A method for preparing an oral dosage form of powder-layered beads containing a therapeutically effective agent, comprising

(A) identifying the bulk density of the therapeutically effective agent to be powder-layered;

(B) identifying a processing aid in the form of a powder having a bulk density which is substantially similar to the bulk density of the theraeutically effective agent, wherein said processing aid is not microcrystalline cellulose;

(C) admixing the therapeutically effective agent with said processing aid to form a homogeneous powder mixture; and

(D) powder-layering inert beads having a diameter from about 0.1 mm to about 2.5 mm with said homogeneous powder mixture until said beads achieve a weight gain of at least about 10% to about 100%.

15. (Amended) A method for preparing an oral dosage form of powder-layered beads containing a therapeutically effective agent having a bulk density from about 0.2 to about 0.8 g/ml, comprising

(A) identifying the bulk density of the therapeutically effective agent to be powder-layered;

(B) identifying a processing aid in the form of a powder having a bulk density from about 0.4 to about 0.9 g/ml which is substantially similar to the bulk density of the therapeutically effective agent, wherein said processing aid is not microcrystalline cellulose;

(C) admixing the therapeutically effective agent with said processing aid to form a homogeneous powder mixture; and

(D) powder-layering inert beads having a diameter from about 0.1 mm to about 2.5 mm with said homogeneous powder mixture until said beads achieve a weight gain of at least